

Work Order ID 134898

Wednesday, July 22, 2015 4:15:26 PM

134898

Page 1

Item ID: D4011-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp, Short
 Start Date: 7/22/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/22/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUL 23 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4011	C								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

12 _____ 02/15/07/09

12 _____ 02/15/07/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 134898

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134898

Page 2

Item ID: D4011-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp, Short

Start Date: 7/22/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/22/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

JUL 30 2015

130

Form as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

h

JUL 30 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

JUL 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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			Lead hand / Supervisor Approval Verification		
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>STS46A</u>	0.00							
150									
Packaging	Memo	0.00				(12) JA	DAS 27 9-29	JUL 30 2015	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SA 20150804

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, July 22, 2015 4:15:26 PM

Page 1

Work Order ID: 134898

134898

Parent Item: D4011-1

D4011-1

Parent Item Name: Clamp, Short

Start Date: 7/22/15

Required Date: 7/22/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

11.05.19 MADE IN HOUSE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

100

sf

123.1000

0.07

0.736842

M304S14GA

304SS sheet .080

02/15/07/29

Location

Loc Qty

Loc Code

MAT019

123.1

M126075

25.5

M129972

97.6

1.8

DQA: _____ Date: _____

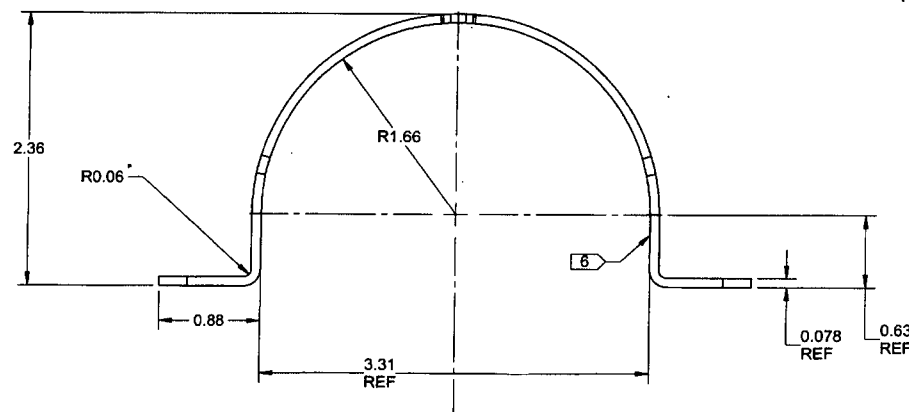
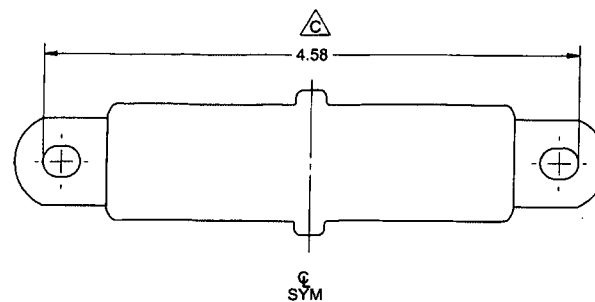


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D4011-1 CLAMP, SHORT

RELEASED

2015 MAR 26

42 EGN 15-532

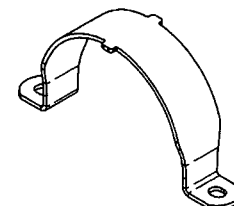


NOTES:

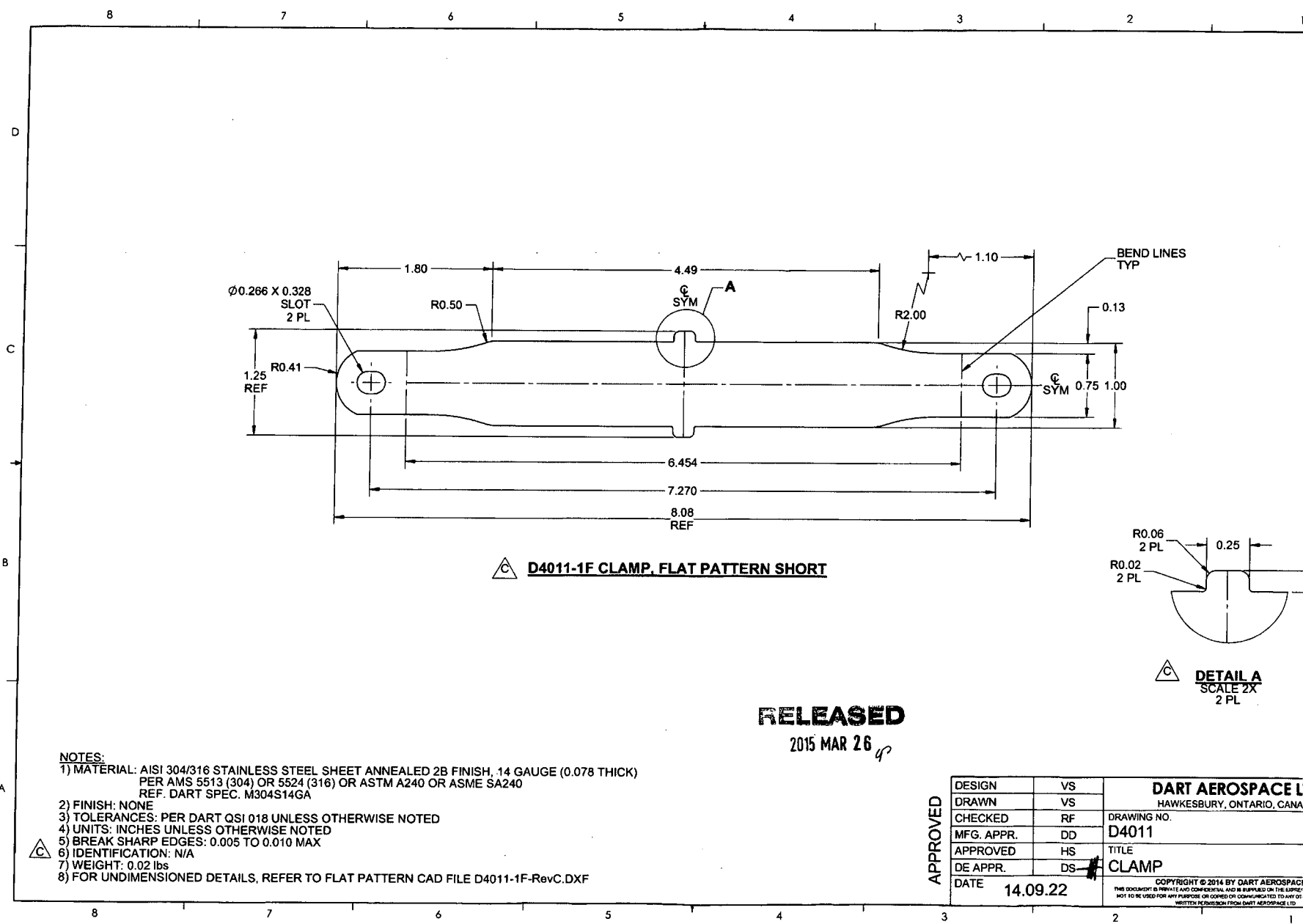
- 1) MATERIAL: MAKE FROM D4011-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-1" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

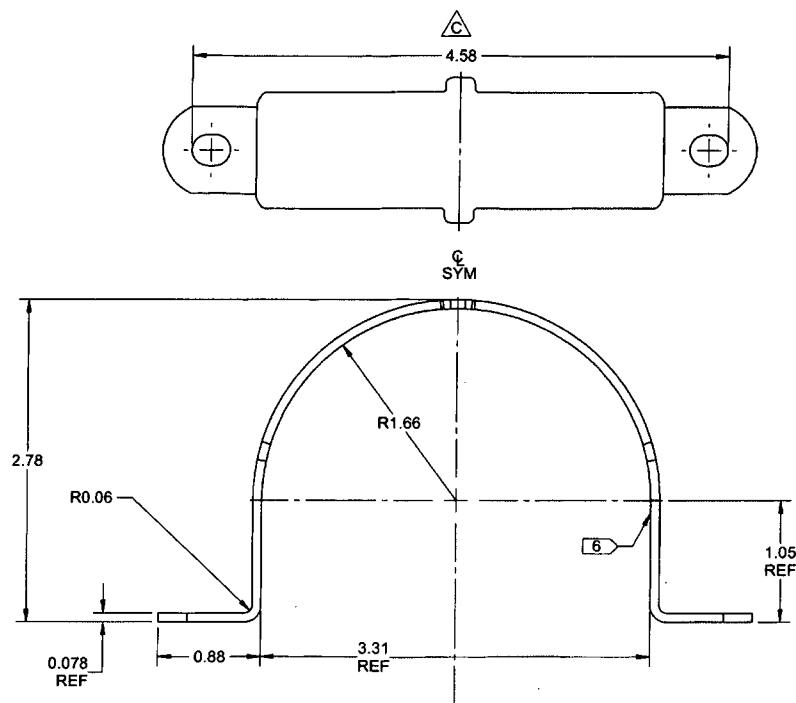
C	ADD SLOT HOLES, ADD CUSHION RETENTION DETAILS TO -1/-3/-5 CLAMPS, REASON: PAR 14-331, NCR 14-3521, PAR 14-368; ZND5-1, A8-1, B8-2, B2-2, D4-3, A8-3, B6-4, B2-4, D5-5, A8-5, B6-6, B2-6, REVISE NOTE 6; ZN A8-2, A8-4, A8-6	VS	14.09.22
B	SHORTEN HEIGHT OF -1/-3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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APPROVED



134898 MLC
15-07-23





D4011-3 CLAMP, LONG

RELEASED

2015 MAR 26 *q*

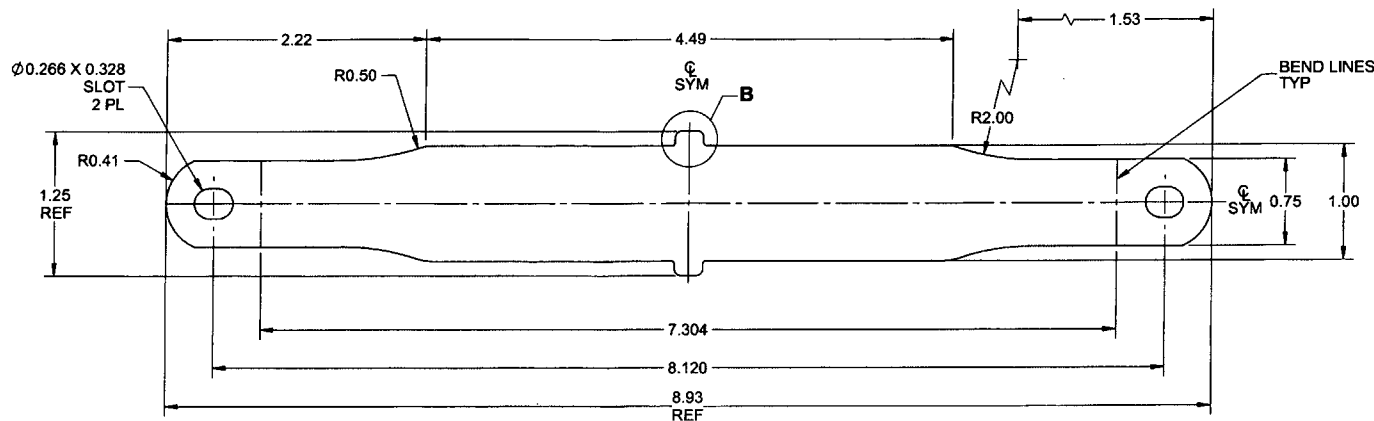
APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
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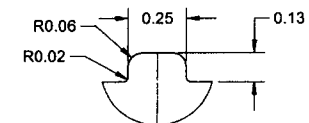


NOTES:

- 1) MATERIAL: MAKE FROM D4011-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-3" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs



D4011-3F CLAMP FLAT PATTERN, LONG



DETAIL B
SCALE 2X
2 PL

RELEASED

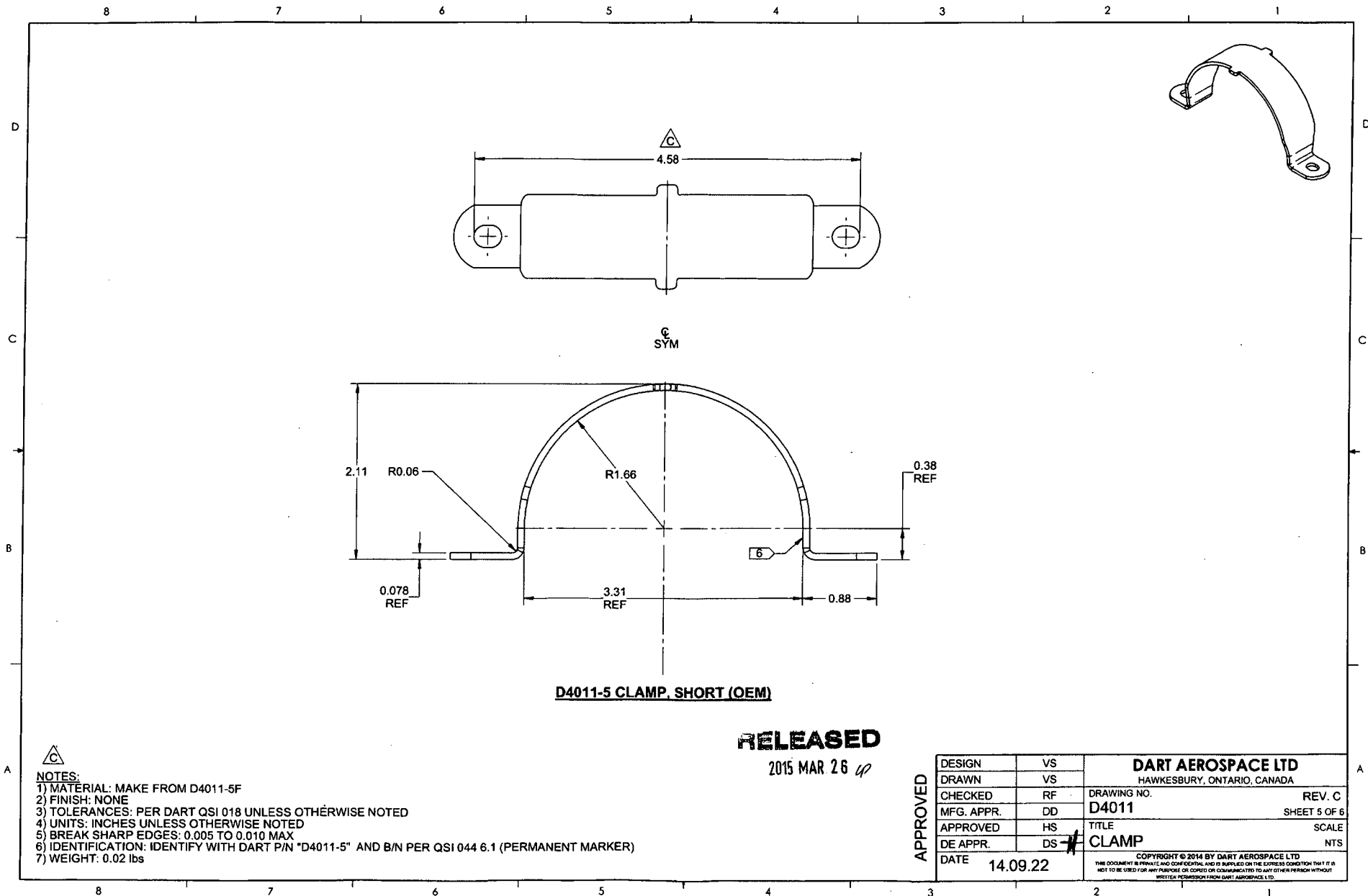
2015 MAR 26

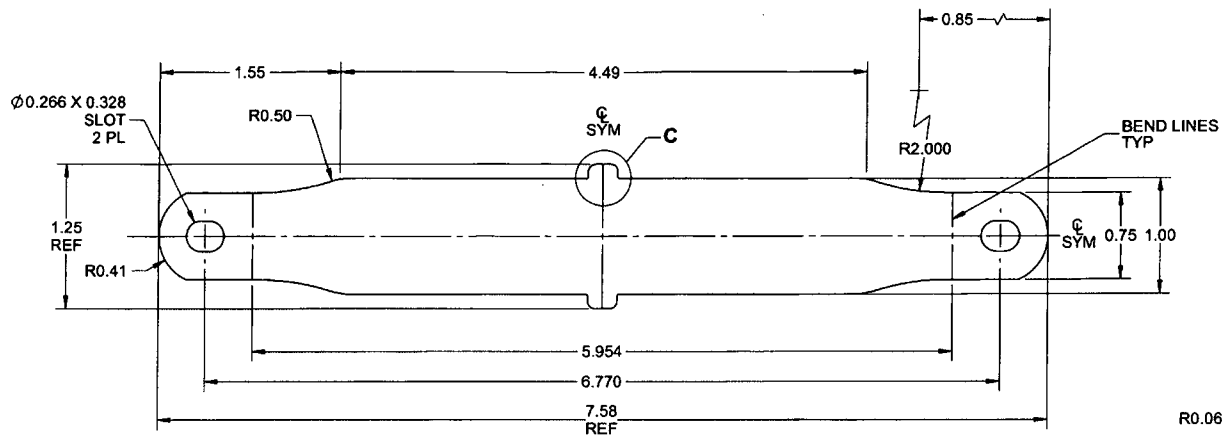
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-3F-RevC.DXF

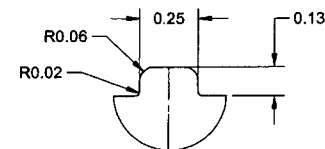
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-5F CLAMP, FLAT PATTERN, SHORT (OEM)



DETAIL C
SCALE 2X

RELEASED

2015 MAR 26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-5F-RevC.DXF

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 6 OF 8
APPROVED	HS	TITLE	SCALE
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